DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-022877
Date Inspected: 06-Apr-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1500
OSM Departure Time: 300
Location: ShangHai, China

CWI Name: Sha Zhi

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 4
This QA Inspector observed the following work in progress for Bay 4.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhang Ya Xu.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail
PCMK: 3025TR2-002-005,006
Welder: 066763
WPS-B-T-2231-ESAB

PCMK: 3026TR1-001-019
Welder: 050977
WPS-B-T-2231-ESAB

PCMK: 3023TR2-002-003
Welder: 214945

WPS-B-T-2231-ESAB

Heat straightening of PCMK, 29TR1-001-001~012, under approved Heat Straightening procedure, HSR 1 (B) 10268, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhang Ya Xu. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 10mm.

Bay 8
This QA Inspector observed the following work in progress for Bay 8.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Huang Min.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Saddle Housing sub-assembly
PCMK: SA7535-005/006
Welder: 054459
WPS-B-T-2231-ESAB

PCMK: SA7535-054
Welder: 500405
WPS-B-T-2231-ESAB

Bay 9
This QA Inspector observed the following work in progress for Bay 9.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Huang Min.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail
PCMK: 3012TR3-001-005
Welder: 059378
WPS-B-T-2231-ESAB

PCMK: 3012TR4-001-008
Welder: 059443
WPS-B-T-2231-ESAB

Bay 10
Heat straightening of PCMK, 29TR1-004, 26TR2-022, under approved Heat Straightening procedure, HSR 1 (B) 10186, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Li Jun. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3

applications. The distortion that was previously measured and recorded on the HSR was Maximum 4mm.

Bay 11
This QA Inspector observed the following work in progress for Bay 11.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Yu Dong Ping.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector

Components: Tower Lift 6
PCMK: SSD1-DPSA6-5-18-33
Welder: 040611
WPS-B-P-2112

Components: Traveler Rail
PCMK: 28TR1-020-003
Welder: 044541
WPS-B-P-2212-TC-U5b

PCMK: 28TR1-020-012
Welder: 046764
WPS-B-P-2212-TC-U5b

PCMK: 28TR1-020-016
Welder: 046714
WPS-B-P-2212-TC-U5b

PCMK: 32TR1-001-009
Welder: 047769
Report: B-WR 20595
WPS-345-SMAW-2G (2F)-Repair

PCMK: 32TR1-002-009
Welder: 002354
Report: B-WR 20595
WPS-345-SMAW-2G (2F)-Repair

Trial Assembly Yard
This QA Inspector observed the following work in progress for Trial Assembly Yard.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhan Hai Feng.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector

Components: 13AE
PCMK: SEG3007AH-144,145
Welder: 068924
Report: B-WR 20568
WPS-345-SMAW-4G (4F)-FCM-Repair-1

PCMK: SEG3007AH-112
Welder: 200113
Report: B-WR20568
WPS-345-SMAW-4G (4F)-FCM-Repair-1

Components: 13AW
PCMK: SEG3013AA-110,116
Welder: 047864
Report: B-WR 20525
WPS-345-SMAW-4G (4F)-FCM-Repair-1

PCMK: SEG3007AH-144,145
Welder: 068924
WPS-345-SMAW-4G (4F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly Yard.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhan Hai Feng.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AE
PCMK: SEG3007Q-164
Welder: 050242
WPS-B-T-2231-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
No relevant conversations
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer